


23/05 SPLIT











Date: Friday, 16/05/2008 7:50:14 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 39313		
Estimate Number	: 10606		
P.O. Number	:	Part Number	: D33193
This Issue	: 16/05/2008 S.O. No. :	Drawing Number	: D3319 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 38091	Material	:
Written By	:	Due Date	: 23/05/2008
Checked & Approved By	:	Qty:	12 Um: Each
Comment	: Est: A 05/05.12 New issue KJ/JLM Est Rev:B Now on Waterjet 06-10-03 JLM		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048
		
	Comment: Qty.: 3.4150 sf(s)/Unit Total : 40.9802 sf(s) 1010/1025/A21/6aA SHEET .048" Thick Batch: 106603 HB 8-5-20	
2.0	WATER JET	FLOW WATER JET
		
	Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B HB 8-5-20 Prog Rev: B 2-Deburr if necessary HB 8-5-20	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary	

N/A Done on step 2.2

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: 6

SV 08/05/21

(11)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SV 08/05/21 (46)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: ____

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	M106762

08-05-29. 7

(8x)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

SV 08/05/29 (8x)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SV 08/05/29 (8x)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:10
OVEN TEMPERATURE: 320°
FINISH TIME: 10:40

F2 08/05/29 (8)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SV 08-05-29 (8)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.

SV 8/5/29

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39313

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX
For Product Eligibility see PDA05-18
and Stock
Location: 496

8/5/29

50 (85)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

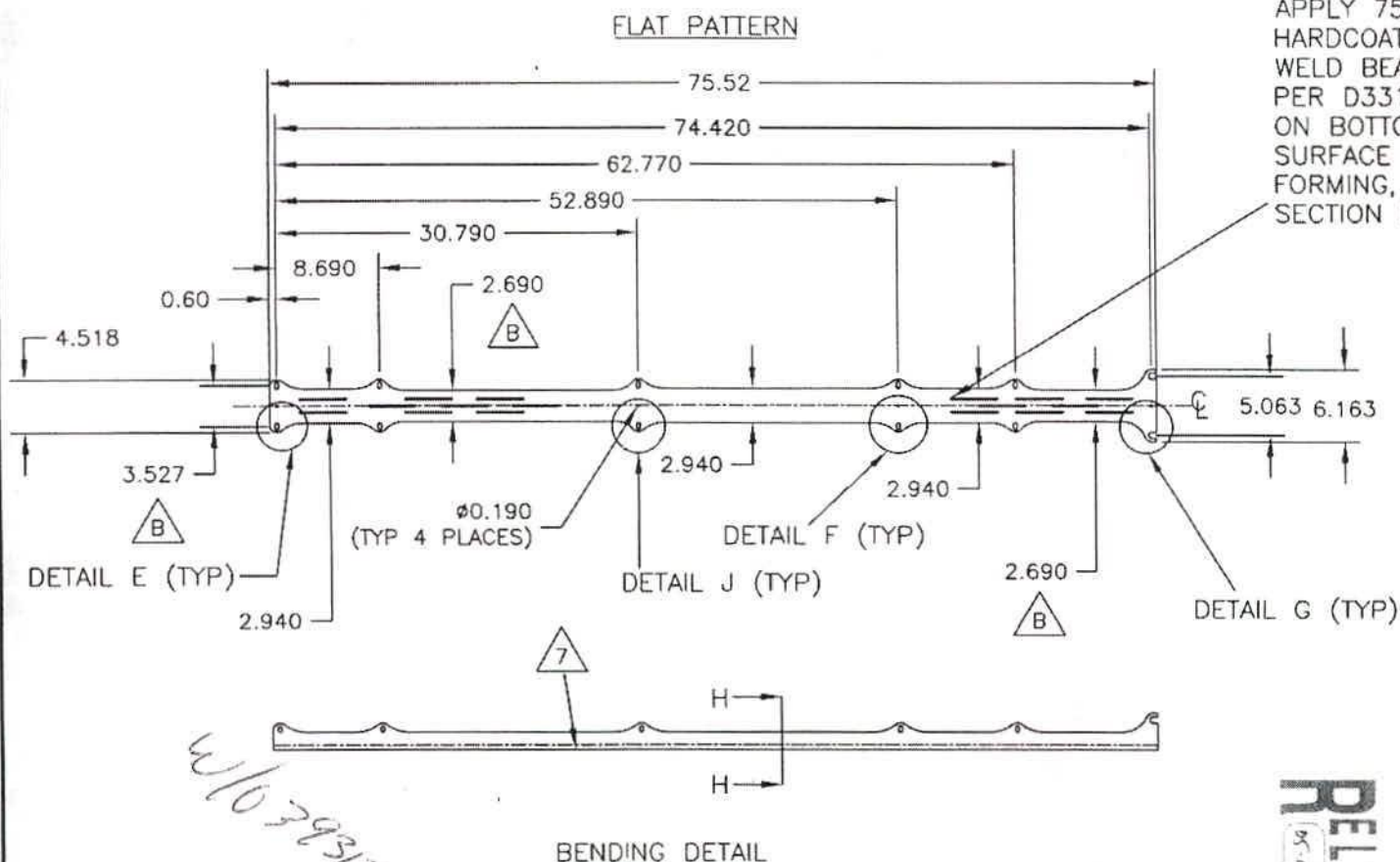


MF 08-05-29

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>GH</i>	APPROVED <i>GH</i>	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 2 OF 5
	TITLE	SCALE
	WEARPLATE	1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



D3319-3 WEARPLATE

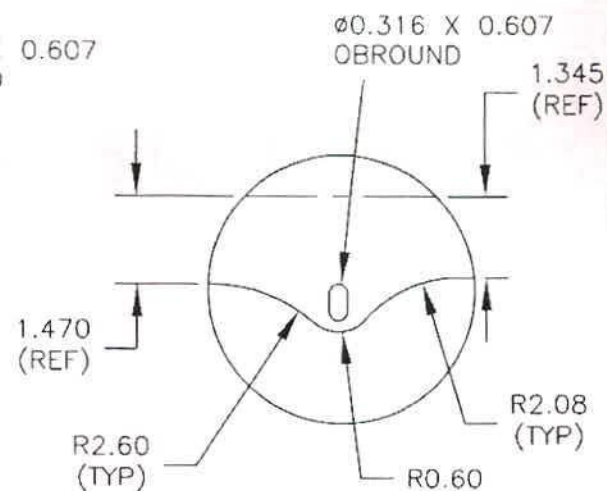
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED

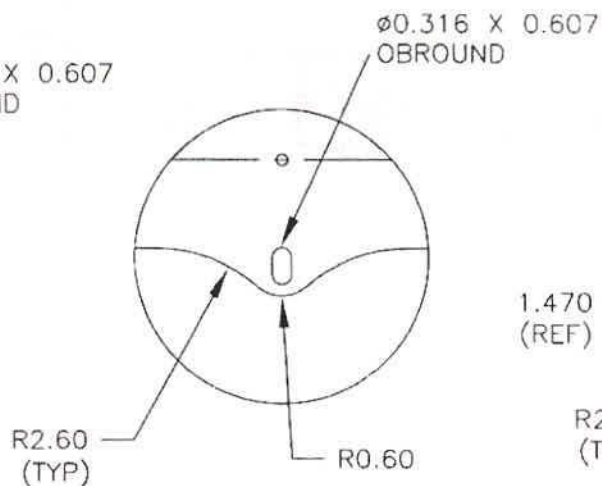
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3319	REV. B
DATE 05.06.06	TITLE WEARPLATE	SHEET 5 OF 5	SCALE 1:3

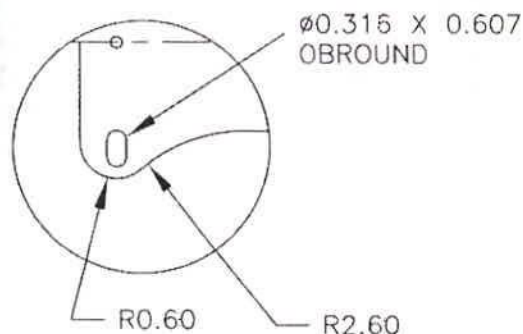
RELEASED
105 00 300 111



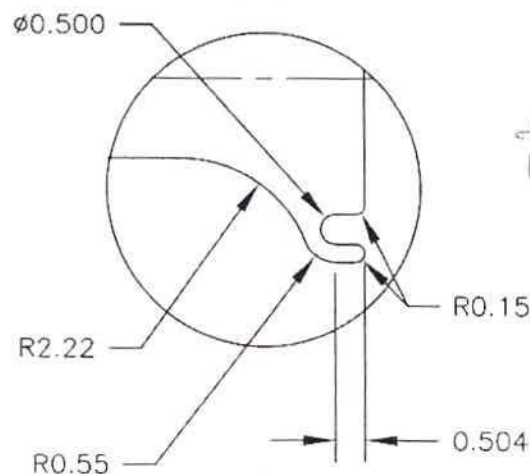
DETAIL J



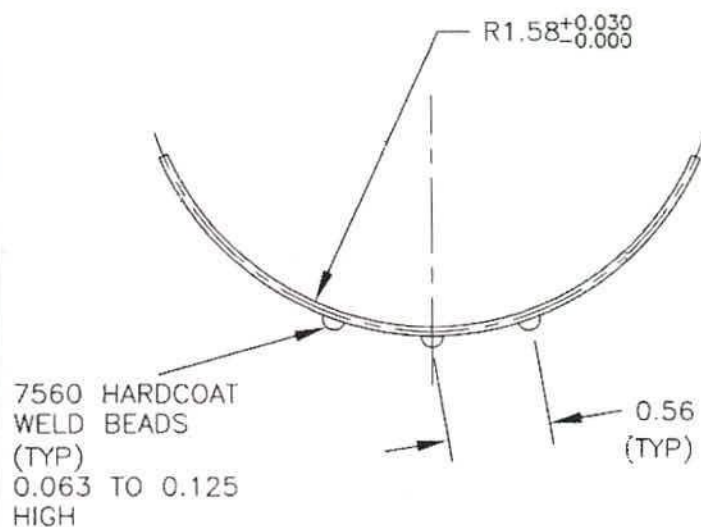
DETAIL F



DETAIL E



DETAIL G



**SECTION H-H
(SCALE 1:1)**

DART AEROSPACE LTD		Work Order: 39313
Description: WEAR PLATE		Part Number: D3319-3
Inspection Dwg: D3319-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .190	+ .005 - .001	.190	X			
Ø .316	+ .006 - .001	.316	X			
.607	+ .008 - .001	.608	X			
Ø .516	+ .006 - .001					
Ø .316	+ .006 - .001	.317	X			
.516	+ .008 - .001					
3.527	+/- .010	3.526	X			
4.518	+/- .010	4.516	X			
2.940	+/- .010	2.949	X			
2.690	+/- .010	2.696	X			
5.063	+/- .010	5.063	X			
6.163	+/- .010	6.165	X			
.60	+/- .030	.595	X			
8.690	+/- .010	8.690	X			
30.790	+/- .010	30.790	X			
52.890	+/- .010	52.890	X			
62.770	+/- .010	62.770	X			
74.420	+/- .010	74.420	X			
75.57	+/- .030	75.52	X			

Measured by: HB
Date: 8-5-20

Audited by: [Signature]
Date: 08/05/20

Prototype Approval: [Signature]
Date: 1/4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	